

Work Order ID 67320

Tuesday, March 15, 2011 10:16:23 AM



Page 1

Item ID: D412-698-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Door Roller, LH

Start Date: 3/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/21/2011 Req'd Qty: 2.00



* Customer:

Reference:

Approvals:

Process Plan:

M

Date: *11-03-15*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-011 CHG003

Subtotal

11-3-31

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/3/31

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Subtotal

11-3-31

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67320

Tuesday, March 15, 2011 10:16:23 AM

Page 2

Item ID: D412-698-011

Accept

Revision ID:

Item Name: Cabin Door Roller, LH

Start Date: 3/15/2011 Start Qty: 2.00

Required Date: 3/21/2011 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging	Packaging	0.00				11/4/7	22		
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-011 Location: <i>60</i>								
	<i>RouB</i>								
140 QC	QC21- Final Inspection - Work Order Release	0.00							11/4/7
Quality Control	Memo	0.00							

11-04-7
2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Tuesday, March 15, 2011 10:16:30 AM

Page 1

Parent Item: D412-698-011





Parent Item Name: Cabin Door Roller, LH

Start Date: 3/15/2011**Required Date:** 3/21/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C04.02.26 Change Qty of D3121-141 & remove D3121-145 from Step 1,3 KJ/DS
IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-141 		Manufactured	No			100	Each	0.0000	<div>3</div>	6			SD
Bracket Assembly										66827	11/4/2		
D3121-143 		Manufactured	No			110	Each	9.0000	<div>1</div>	2			SD
Bracket Assembly										11/3/31			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235A				9					
				61340				1					
				61406				8					
D3183-043 		Manufactured	No			110	Each	5.0000	<div>1</div>	2			SD
Bracket Assembly										11/3/38			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST236				5					
				62001				5					
D3137-043 		Manufactured	No			110	Each	3.0000	<div>1</div>	2			2x
Bracket Assembly										11/3/31			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235B				3					
				62831				3					

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Tuesday, March 15, 2011 10:16:30 AM

Work Order ID: 67320



Parent Item: D412-698-011



Parent Item Name: Cabin Door Roller, LH

Start Date: 3/15/2011

Required Date: 3/21/2011

Start Qty: 2.00

Required Qty: 2.00

D3199-1

Manufactured No

110

Each

88.0000



11/3/31

Bracket

Location

Loc Qty

Loc Code

ST236A

88

61484

38

66830

50

18

D3202-1

Manufactured No

110

Each

14.0000



11/3/31

Cover

Location

Loc Qty

Loc Code

ST241A

14

59693

4

66252

10

2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

• COPYRIGHT © 2003 BY DART AEROSPACE LTD. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: E
Date: 08.05.01